



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3407-1

Job Sheet 210787



Part No: D3407-1

Job Qty: 24 pcs

Part Name: Stem



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/22/20

Job Tracking No:

Due Date: 7/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC IPP REV:D 17.11.02 AS PER DWG REV.G DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Setup Run Hrs Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
100	Doosan - 1	24 pcs		7/10/20	1.00	9.64	Doosan - 1		De
110	QC 2	24 pcs		7/10/20	0.00	0.00	QC 2 - 1		20-07-18
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S288911



Part: D3407 - 1
Job No: 210787
Serial No/Batch: S288911
Revision: G
Inspector:
Exp Date:
Instructions: Various STC's

DART Aerospace Ltd.
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www.dartaerospace.com

Date: 07/16/20



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Container No: S288911



Part: D3407-1

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Instructions: Various STC's

Date: 07/10/20

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	24 pcs	7/10/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Packaging 3-1 - Stock - B4B	24 pcs	7/10/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B

mk 20/07/18

12

JUL 20 2020

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	24 pcs	7/10/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-09 JUL 20 2020
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	

Part Op 100 - 1-Turn as per Folio FA596 Rev: 4A & Dwg D3407 Rev: G Mill slot width at max tolerance .260" 2-Debur
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: WA001) LOCATION: WA001
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.750	17-4 Round Bar .750	11.0160 ft (.459 ea)	100-Doosan - 1	S257176

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-R0.750	11	25	0

→ 11,308
 → SC 9292

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.063Inches $\pm$ 0.010	1 0.073 0.053	.06	
2	Tow Ring	0.26520Inches + 0.00160 - 0.00170	1 0.26680 0.26350	.265	1/4-28 UNF WIFE 24
3	Tow Ring	0.24575Inches $\pm$ 0.00325	1 0.24900 0.24250	.2468	Major $\diamond$
4	Tow Ring	0.625Inches $\pm$ 0.010	1 0.635 0.615	.6245	
5	Tow Ring	0.363Inches $\pm$ 0.010	1 0.373 0.353	.3635	
6	Tow Ring	0.750Inches $\pm$ 0.010	1 0.760 0.740	.745	
7	Tow Ring	0.100Inches $\pm$ 0.010	1 0.110 0.090	R.1	Radius
8	Tow Ring	0.470Inches $\pm$ 0.010	1 0.480 0.460	.469	
9	Tow Ring	0.500Inches $\pm$ 0.010	1 0.510 0.490	.498	
10	Tow Ring	3.25Inches $\pm$ 0.01	1 3.26 3.24	3.255	
11	Tow Ring	4.250Inches + 0.000 - 0.010	1 4.250 4.240	4.244	
12	Tow Ring	5.270Inches $\pm$ 0.010	2 5.280 5.260	5.27	
13	Tow Ring	0.150Inches $\pm$ 0.010	2 0.160 0.140	.153	
14	Tow Ring	0.550Inches $\pm$ 0.010	2 0.560 0.540	.554	
15	Tow Ring	0.625Inches $\pm$ 0.010	2 0.635 0.615	.627	
16	Tow Ring	0.250Inches + 0.010 - 0.000	2 0.260 0.250	.256	

Plex 6/22/20 3:13 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					